

Work Order ID 52326

Tuesday, September 22, 2009 3:11:53 PM



Page 1

Item ID: D3500-1	Accept		Setup	Start	
Revision ID: C				Stop	
Item Name: Saddle					
Start Date: 9/23/2009	Start Qty: 20.00				
Required Date: 10/9/2009	Req'd Qty: 20.00				
			Cust Item ID:		
			Customer:		

Reference:

Approvals:	Process Plan:	Date: 09-24	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr

100	HAAS CNC VERTICAL MACHINING #1	0.00							
-----	--------------------------------	------	--	--	--	--	--	--	--



HAAS 1
HAAS CNC vertical machine #1

Memo
Program Batch No. 52326 Double check by: ☐ 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA641 and inspect p

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--



QC
Quality Control

Memo

0.00

09/10/23

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--



QC
Quality Control

Memo

0.00

09/10/23

Work Order ID 52326

Tuesday, September 22, 2009 3:11:53 PM



Page 3

Item ID: D3500-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Saddle

Start Date: 9/23/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 429

0.00



Packaging

Memo

0.00

Packaging

Rec'd 9/27 (20)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.10.27
MF
09-10-27

Picklist Print

Tuesday, September 22, 2009 3:11:53 PM

Page 1

Work Order ID: 52326



Parent Item: D3500-1RevC



Parent Item Name: Saddle

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-013RevD		Manufactured	No			100	Each	30.0000	20.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

30

41962

1

46414

29

20 JK 09/10/23

DART AEROSPACE LTD		Work Order: 52326	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.499		
H									
I	R1.575	R1.595		1.589	1.588	1.588	1.588		
J	0.240	0.260		.247	.247	.247	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.640	3.640	3.640	3.640		
M	0.315	0.322		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.509	6.509	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.547	.547	.546	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.050	.050	.050		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.255	.255	.256	.255		
AE	1.810	1.830		1.821	1.822	1.822	1.822		
AF	0.240	0.260		.251	.252	.252	.252		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.149	.150	.150	.149		
AI	0.140	0.160		.154	.155	.154	.152		
Accept/Reject									

Measured by:	
Date:	09/10/17

Audited by:	
Date:	09/10/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 52326	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	
		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.376	.375	.375		
F	0.490	0.510		.501	.499	.500	.500		
H									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.247	.246	.246	.247		
K	0.490	0.510		.500	.500	.499	.500		
L	3.590	3.650		3.640	3.640	3.640	3.640		
M	0.315	0.322		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.548	.550	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.255	.253	.254	.254		
AE	1.810	1.830		1.821	1.821	1.822	1.821		
AF	0.240	0.260		.252	.250	.251	.251		
AG	0.140	0.160		.150	.152	.153	.152		
AH	0.140	0.160		.149	.153	.151	.151		
AI	0.140	0.160		.152	.152	.153	.153		
Accept/Reject									

Measured by:	SL
Date:	09/10/17

Audited by:	SL
Date:	09/10/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 52326
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.375	.375	.375		
F	0.490	0.510		.501	.501	.500	.500		
H									
I	R1.575	R1.595		1.588	1.589	1.588	1.588		
J	0.240	0.260		.247	.247	.246	.247		
K	0.490	0.510		.499	.500	.500	.501		
L	3.590	3.650		3.640	3.640	3.640	3.640		
M	0.315	0.322		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.509	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.550	.548	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.135	1.134	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.253	.253	.254	.254		
AE	1.810	1.830		1.821	1.821	1.821	1.821		
AF	0.240	0.260		.250	.250	.251	.251		
AG	0.140	0.160		.152	.153	.151	.151		
AH	0.140	0.160		.154	.154	.152	.153		
AI	0.140	0.160		.154	.154	.152	.153		
Accept/Reject									

Measured by:	SL
Date:	09/10/18

Audited by:	86
Date:	09/10/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD		Work Order: 52326	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.498		
H									
I	R1.575	R1.595		1.589	1.589	1.585	1.588		
J	0.240	0.260		.246	.245	.246	.247		
K	0.490	0.510		.499	.500	.499	.500		
L	3.590	3.650		3.640	3.640	3.640	3.640		
M	0.315	0.322		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.509	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.546	.549	.549	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.136	1.136	1.132	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.253	.253	.253	.253		
AE	1.810	1.830		1.822	1.822	1.821	1.822		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.151	.151	.150	.149		
AH	0.140	0.160		.152	.150	.153	.151		
AI	0.140	0.160		.154	.151	.153	.151		
Accept/Reject									

Measured by:	JL
Date:	09/10/22

Audited by:	SL
Date:	09/10/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	24

DART AEROSPACE LTD		Work Order: 52326	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	Page 1 of 1

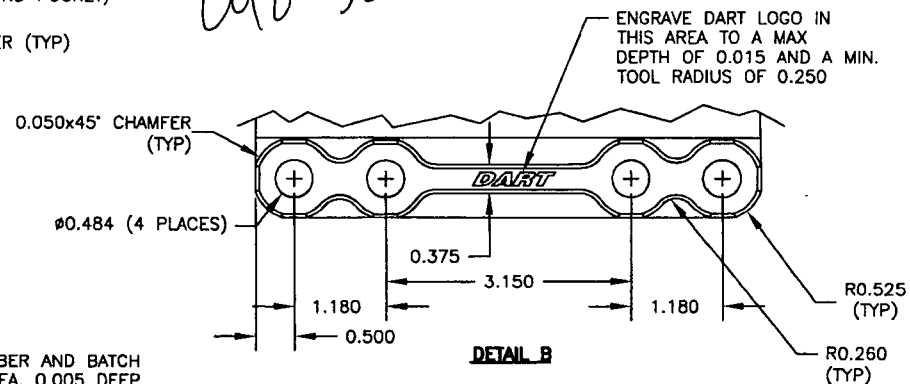
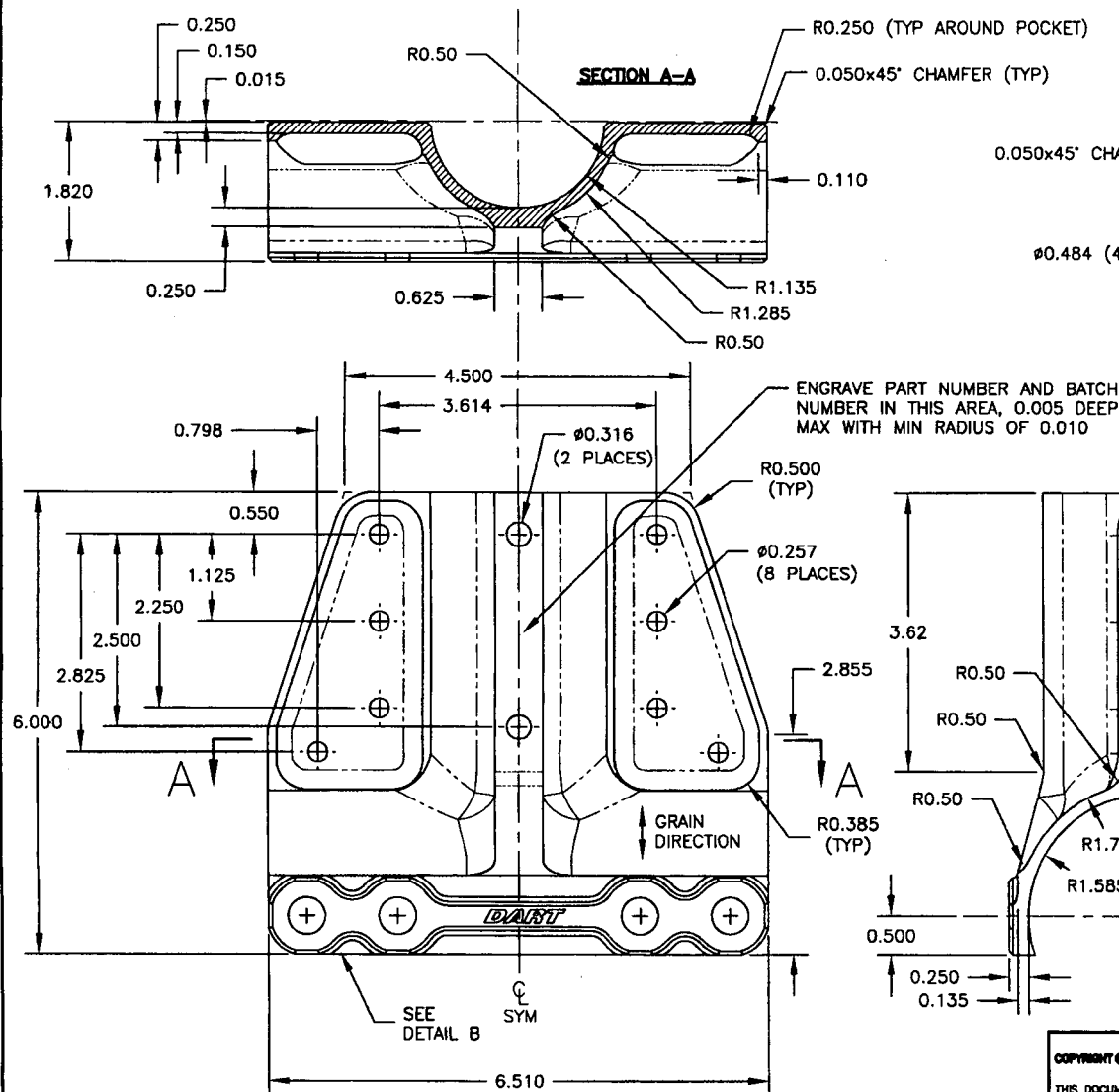
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
I	R1.575	R1.595		1.585	1.587	1.586	1.584		
J	0.240	0.260		.246	.246	.245	.247		
K	0.490	0.510		.500	.500	.500	.501		
L	3.590	3.650		3.640	3.640	3.640	3.640		
M	0.315	0.322		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.509	6.509	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.550	.548			
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.135	1.135	1.134	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.253	.254	.254	.255		
AE	1.810	1.830		1.822	1.821	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.149	.150	.149	.150		
AH	0.140	0.160		.149	.152	.151	.152		
AI	0.140	0.160		.152	.149	.151	.152		
Accept/Reject									

Measured by:	SL
Date:	09/10/22

Audited by:	SL
Date:	09/10/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

WLO 52326



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1. POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 #

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
		REV. C SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.